



**Work Order ID 121265****\*121265\***

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Item ID: D206-811-015

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: 206L Replacement Engine Mount

Start Date: 6/20/14 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 6/20/14 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Packaging						<b>DAS</b>		
Packaging	Memo	0.00					<b>06</b>		
Packaging	Identify and pack for shipping as per PPP D206-811-015						<b>06</b>		
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

JUN 23 2014

MLJ 1406-23

WU-023

June-20-14 8:52:54 AM

**\*121265\***

**\*D206-811-015\***

**Start Date:** 6/20/14**Required Date:** 6/20/14**Start Qty: 2.00**

**Required Qty: 2.00**

**Comments:** IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM  
REV:B 14.06.19 AS PER IIN REV.B DD VERF:JLM

IPP

[illegible]

*Ref only*  
*SNP*  
*14/6/03*

**Table 2. – Fastener Torque**

Fastener Type	Torque (in-lbs)	Torque (N*m)
1/4-28 <b>T<sub>1</sub></b>	25-35	2.8-4.0
1/4-28 <b>T<sub>2</sub></b>	50-70	5.7-7.9
3/8-24 <b>T<sub>3</sub></b>	70-90	7.9-10.2
3/8-24 <b>T<sub>4</sub></b>	105-115	11.9-13.0
3/8-24 <b>T<sub>5</sub></b>	100-140	11.3-15.8

#### 4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the D206-811-015 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-811-015 REPLACEMENT ENGINE MOUNT KIT (206L Models)	0.7 lb 0.32 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	160.2 in 4.07 m	112 in-lb 1.3 m-kg

#### 5.0 PARTS LIST

Qty -015	Part Number	Description
X	D206-811-015	REPLACEMENT ENGINE MOUNT KIT (206L Models)
1	D4866-041	AFT LEG ASSEMBLY, LH
1	D4866-042	AFT LEG ASSEMBLY, RH
2	D4867-041	FWD LEG ASSEMBLY
1	D4868-041	LEG ASSEMBLY, LH
1	D4868-042	LEG ASSEMBLY, RH